

Work Order ID 73716

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73716

Page 1

Item ID: D3537-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearpad

Start Date: 9/14/11 Start Qty: 80.00

80

Cust Item ID:

Required Date: 9/23/11 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3537Dwg Rev: C Prog Rev: C 2-Deburr if necessary

B12-2-5

95

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-2-5

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/26/10

count
895

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Item ID: D3537-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearpad
 Start Date: 9/14/11 Start Qty: 80.00 ***80*** Cust Item ID:
 Required Date: 9/23/11 Req'd Qty: 80.00 ***80*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | NC BRAKE | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Brake NC | Memo | 0.00 | | | | | | | |
| Brake NC | 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2- Identify as D3537-1 | | | | | | | | |
| | | | | | | | | | |
| 140 | Large Fab | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | Qty Description BatchA/R 2059B Hardcoat m120392 1-Weld as per Dwg D3537 using Jig DT 82102-Remove any weld that penetrated through Wearpadif necessary | | | | | | | | |
| | | | | | | | | | |
| 150 | QC10- Inspect visual per QS1004- ground welds | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

95

SB 12/02/09

85

12-04-11 JBL

canbs
785

8/17/04/12

Dart Aerospace Ltd

| W/O: 73716 | | WORK ORDER CHANGES | | | | | |
|------------|------|--|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 12.02.23 | | look up for "Linda" / David D to test for robot testing | MA | 12.02.23 | | Li 12.02.23 | J 12/02/23 |
| | | | | | | | |

Part No: D3537-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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Item ID: D3537-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearpad

Start Date: 9/14/11

Start Qty: 80.00

80

Cust Item ID:

Required Date: 9/23/11

Req'd Qty: 80.00

80

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 170 | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| Powdercoat | | | | | | | | | |
| Powder Coating | | | | | | | | | |
| | Memo | 0.00 | | | | | | | |
| | START TIME: 9:45 | | | | | | | | |
| | FINISH TIME: 10:15 | | | | | | | | |
| 180 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

count
45

85X

m/f
12/04/14

85

m/f
12 04 14

M117338

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Item ID: D3537-1 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Wearpad
 Start Date: 9/14/11 Start Qty: 80.00 ***80*** Cust Item ID:
 Required Date: 9/23/11 Req'd Qty: 80.00 ***80*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 190 | Identify as per dwg & Stock Location: F-P 2 | 0.00 | | | | | | | |
| *190* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 200 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *200* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

85x

mk
12/04/14

12/4/17

12-04-14

Picklist Print

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Work Order ID: 73716

Parent Item: D3537-1

Parent Item Name: Wearpad

Start Date: 9/14/11

Required Date: 9/23/11

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S16GA 304/316 Sheet .063 | | Purchased | No | | | 100 | sf | 28.4700 | 0.106 | 8.9263158 | 10 | | |

1812-2-5

Location

Loc Qty

Loc Code

MAT020

28.47

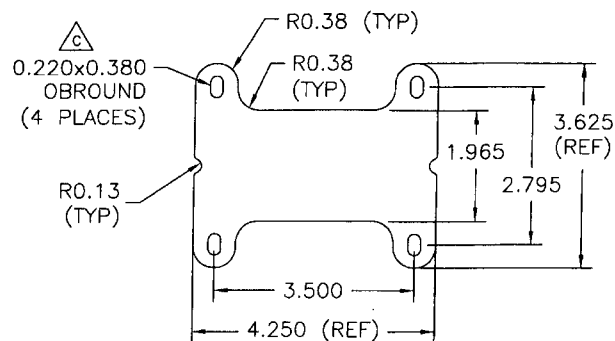
120243

28.47

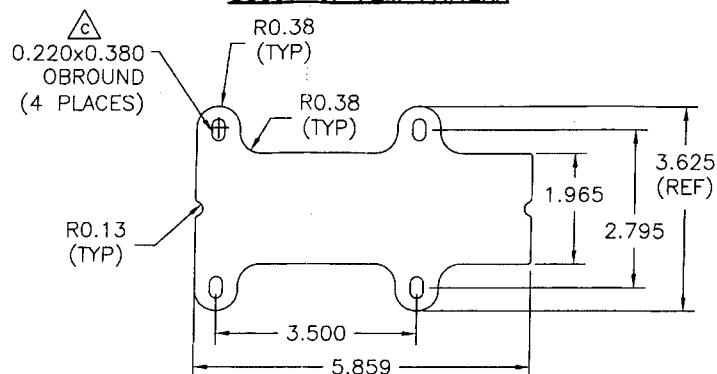
120243

95

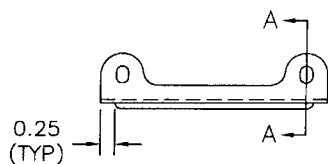
D3537-1F FLAT PATTERN



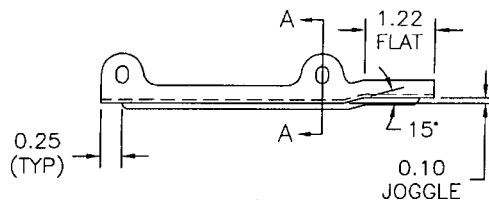
D3537-3F FLAT PATTERN



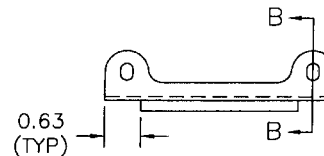
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



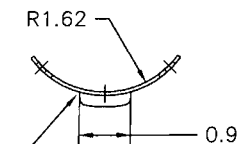
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

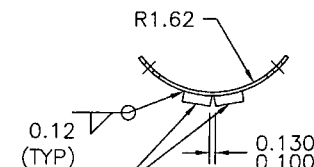
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

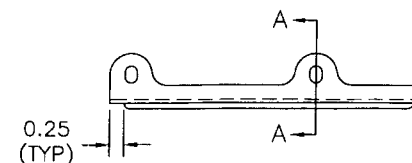
SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

RELEASED
07.05.08 PM
PER ECN 962

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



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| | | | | |
|---------|----------|-------------|--------|--------------------------|
| DESIGN | C.B. | DRAWN BY | PH | DART AEROSPACE USA, INC. |
| CHECKED | # | APPROVED | # | PORT HADLOCK, MA |
| DATE | 07.04.13 | DRAWING NO. | D3537 | REV. C |
| TITLE | WEARPAD | SHEET | 1 OF 1 | SCALE |
| | | | | 1:2 |